

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 132395

132395

Page 2

May-07-15 2:36:31 PM

Item ID: D2933-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH In, 206
 Start Date: 5/07/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 2:45 OVEN TEMPERATURE: 350								
	FINISH TIME: 3:15								

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 132395

132395

Page 3

May-07-15 2:36:31 PM

Item ID: D2933-2 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 5/07/15 Start Qty: 6.00 ***6*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									JUN 09 2015
170	Identify as per dwg & Stock Location: <u>S/396</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									JUN 10 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									JUN 11 2015

ML5 JUN 10 2015

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Picklist Print

May-07-15 2:36:30 PM

Page 1

Work Order ID: 132395

132395

Parent Item: D2933-2

D2933-2

Parent Item Name: Saddle RH In, 206

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	39.0000	1	6			
D6101-001									**	<u>6</u>		DAS 20 9-89	15-06-01
Saddle Billet													

Location

Loc Qty

Loc Code

MAT042

36

129986

36

MAT045

3

125829

3

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DART AEROSPACE LTD	Work Order:	132385
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.122	.122		
B	0.100	0.140		.123	.123	.124	.123		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230	.221	.219	.219	.219	.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.120	.118	.119	.120		
O	0.540	0.560		.549	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.491	2.492	2.492	2.492		
S	0.240	0.270		.251	.250	.248	.249		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.1345	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.574	1.573	1.574	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	FK
Date:	15/06/02

Audited by:	D.A.	DAS
Date:	15/06/04	08
		9-05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 13235
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

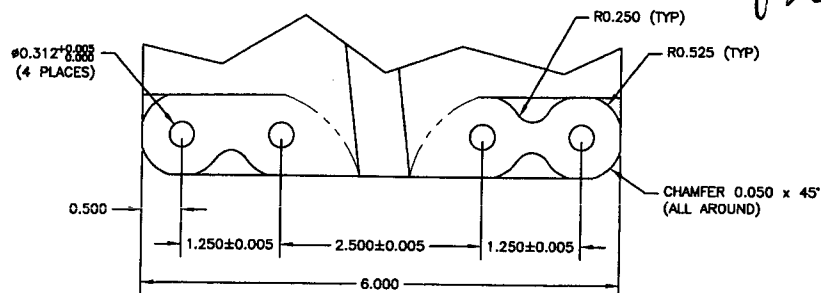
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	3	4		
A	0.100	0.140		.123	.124				
B	0.100	0.140		.123	.123				
C	0.100	0.140		.121	.120				
D	0.210	0.230		.218	.218				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.120	.120				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.249	.250				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.1355	1.1355				
Y	1.565	1.585	DT8695 A/B	1.574	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	FL
Date:	15/06/02

Audited by:	DAS	DAS
Date:	15/06/04	08 9-09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

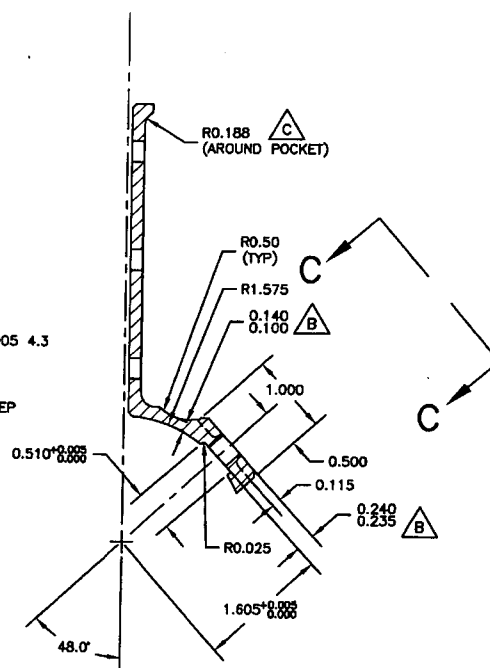


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

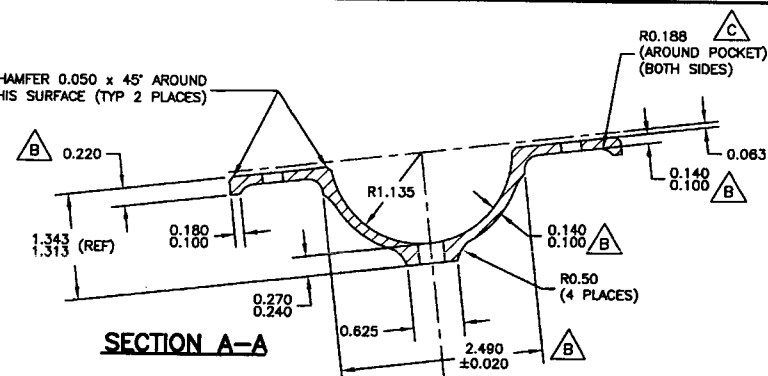
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

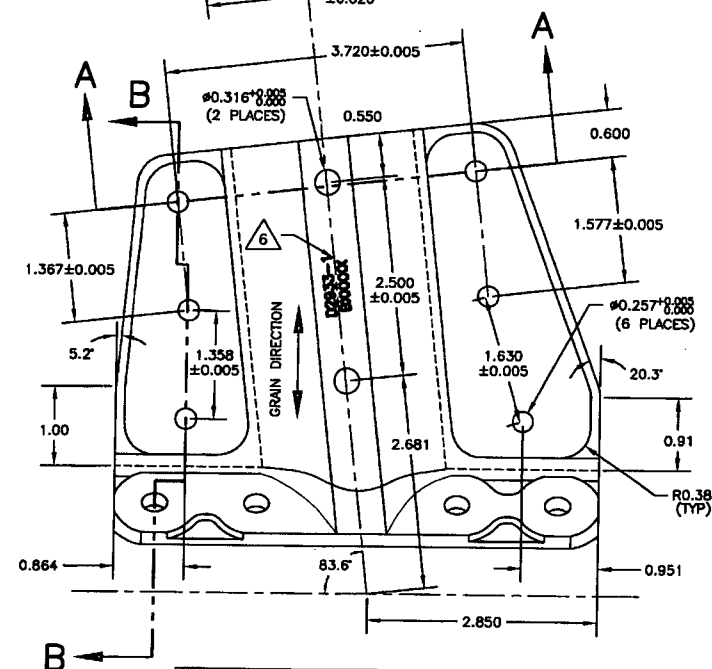


SECTION B-B

CHAMFER $0.050 \times 45^\circ$ AROUND
THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	DRAWING NO. D2933
		TITLE SADDLE INSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLVILLE, TX

REV. C

SHEET 1 OF 1

SCALE

2:3



Part Number: D2933-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 132395

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
A	0.120	+0.020/-0.020	0.124	0.123	0.122	0.122	
B	0.120	+0.020/-0.020	0.123	0.123	0.124	0.123	
C	0.120	+0.020/-0.020	0.120	0.120	0.120	0.120	
D	0.220	+0.010/-0.010	0.220	0.219	0.219	0.219	
E	1.250	+0.005/-0.005	1.250	1.250	1.250	1.251	
F	1.250	+0.005/-0.005	1.249	1.249	1.249	1.249	
G	2.500	+0.005/-0.005	2.500	2.500	2.500	2.500	
H	0.510	+0.005/0.000	0.511	0.511	0.511	0.511	
I	1.577	+0.005/-0.005	1.577	1.577	1.578	1.577	
J	2.500	+0.005/-0.005	2.498	2.498	2.499	2.499	
K	0.2570	+0.0050/-0.0010	0.2577	0.2575	0.2571	0.2573	
L	0.3120	+0.0050/-0.0010	0.3121	0.3130	0.3130	0.3111	
M	0.235	+0.005/0.000	0.239	0.239	0.239	0.239	
N	0.120	+0.020/-0.020	0.120	0.119	0.120	0.120	
O	0.550	+0.010/-0.010	0.550	0.551	0.551	0.551	
P	0.500	+0.010/-0.010	0.498	0.500	0.499	0.496	
Q	3.720	+0.005/-0.005	3.719	3.719	3.719	3.719	
R	2.490	+0.020/-0.020	2.494	2.494	2.494	2.494	
S	0.255	+0.015/-0.015	0.250	0.250	0.248	0.249	
T	0.140	+0.020/-0.020	0.135	0.135	0.135	0.135	
U	1.630	+0.005/-0.005	1.630	1.630	1.631	1.630	
V	1.367	+0.005/-0.005	1.368	1.369	1.367	1.367	
W	0.3160	+0.0050/-0.0010	0.3152	0.3152	0.3150	0.3153	
X	1.135	+0.010/-0.010	1.136	1.135	1.136	1.136	
Y	1.575	+0.010/-0.010	1.574	1.573	1.574	1.574	
Z	0.188	+0.010/-0.010	0.187	0.188	0.187	0.187	

Measured by:
Mathieu Lamarche

Date:
2015-6-3

Audited by:

DAS
08
9-8c

Date:

15/06/04



Part Number: D2933-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 132395

Item Ref.	Nominal	Tolerance	No. Piece_5 Actual	1. No. Piece_6 Actual			
A	0.120	+0.020/-0.020	0.123	0.123			
B	0.120	+0.020/-0.020	0.123	0.123			
C	0.120	+0.020/-0.020	0.121	0.120			
D	0.220	+0.010/-0.010	0.219	0.219			
E	1.250	+0.005/-0.005	1.249	1.250			
F	1.250	+0.005/-0.005	1.249	1.249			
G	2.500	+0.005/-0.005	2.501	2.500			
H	0.510	+0.005/0.000	0.511	0.511			
I	1.577	+0.005/-0.005	1.578	1.577			
J	2.500	+0.005/-0.005	2.500	2.500			
K	0.2570	+0.0050/-0.0010	0.2570	0.2569			
L	0.3120	+0.0050/-0.0010	0.3120	0.3128			
M	0.235	+0.005/0.000	0.239	0.239			
N	0.120	+0.020/-0.020	0.120	0.120			
O	0.550	+0.010/-0.010	0.550	0.550			
P	0.500	+0.010/-0.010	0.499	0.499			
Q	3.720	+0.005/-0.005	3.718	3.718			
R	2.490	+0.020/-0.020	2.494	2.494			
S	0.255	+0.015/-0.015	0.249	0.251			
T	0.140	+0.020/-0.020	0.135	0.135			
U	1.630	+0.005/-0.005	1.629	1.630			
V	1.367	+0.005/-0.005	1.367	1.368			
W	0.3160	+0.0050/-0.0010	0.3153	0.3152			
X	1.135	+0.010/-0.010	1.136	1.135			
Y	1.575	+0.010/-0.010	1.574	1.574			
Z	0.188	+0.010/-0.010	0.188	0.187			

Measured by:
Mathieu Lamarche

Date:
2015-6-3

Audited by:

DAS
08
9-88

Date:

15/06/04